

Work Order ID 153475

Monday, November 21, 2016 9:23:16 AM

153475

RUSH!

Page 1

Item ID: D3294-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket For Interior Window For -115
 Start Date: 11/14/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 11/21/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: NOV 21 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3294	D							DAS 46 9-89	17/01/22 17/01/22

100 0.00 ***100*** 4

Waterjet Memo 0.11
 FLOW CNC Waterjet
 1-Cut as per Dwg D3294
 CUt File D3294-3
 Dwg Rev: D
 Prog Rev: D
 *grain direction on a 45 deg as per dwg**
 2-Deburr if necessary

110 0.00 ***110*** 4 DAS 46 9-89 17/01/23
 QC Memo 0.01
 Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

153475

Monday, November 21, 2016 9:23:16 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

4

Cust Item ID:

Start Date: 11/14/2016 **Start Qty:** 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 QC8- Inspect parts - second check

0.00

120

0.01

QC

Memo

Quality Control

DAS
38
9-89
JAN 24 2017

130 0.06

130

0.07

Brake NC

Memo

Brake NC

1-Deburr if necessary
2-Bend as per Dwg D3294
(Ensure angle is correct)

**DAS
30
9-89**

④

FEB 07 2017

140	QC5- Inspect part completeness to step on W/O	0.00
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140

0.01

QC

Memo

Quality Control

DAS
38
9-89

4

FEB 07 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order ID 153475

Monday, November 21, 2016 9:23:16 AM

153475

Page 3

Item ID: D3294-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket For Interior Window For -115

Start Date: 11/14/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/21/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.05

Hand Finishing

X4

Ø

2017/02/08

BEB

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.01

Quality Control

4x

17/02/08 DAS 36 8-89

170

0.00

170

Small Fab

Memo

0.04

Small Fab

1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

4x

17/02/08 DAS 36 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

153475

Monday, November 21, 2016 9:23:16 AM

N900040100

Setup Start *NS1*

Stop ***NS2***

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

180

0.01

Memo

FEB 08 2017

0.00

190

0.03

Memo

Start Time: 1.00
Oven Temperature: 325°
Finish Time: 1.35

0.00

200

0.01

Memo

FEB 08 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Revision ID: Stop ***NS2***
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Start Date: 11/14/2016 Start Qty: 4.00 ***4*** Cust Item ID:
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210	Identify as per dwg & Stock Location: <u>5435</u>	0.00							
210									
Packaging	Memo	0.01							
Packaging									
220	QC21 - Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.07							
Quality Control									

17-2-08

DQA: _____ Date: _____



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OTHER : _____																																																																				

Picklist Print

Monday, November 21, 2016 9:23:15 AM

Work Order ID: 153475

153475

Parent Item: D3294-1

D3294-1

Parent Item Name: Bracket For Interior Window For -115

Start Date: 11/14/2016

Required Date: 11/21/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A04.08.24New issueKJ/JLM
IPP Rev:B Now On Waterjet 07-03-26 JLM
IPP Rev:C 08-07-16 Redesign part DD verified by:EC
IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	31.6100	1.8	7.578947			
									**			DAS 46 9-89	17/01/23
M2024T3S 080													
2024-T3 .080 sheet													

Location	Loc Qty	Loc Code
MAT021	31.61	
M127668	3	
M129584	10.2	
M129891	9.71	
M135288	8.7	

D3294-5		Manufactured	No			170	Each	7.0000	1	4	13		
									**			17/02/08	DAS 36 9-89
D3294-5													
Doubler													

Location	Loc Qty	Loc Code
GA	7	
129537	1	
149563	2	
150320	4	

MS20470AD4-5		Purchased	No			170	Each	981.0000	15	60	4		
									**			17/02/08	DAS 36 9-89
MS20470AD4-5													
RIVET, UNIVERSAL HEAD													

Location	Loc Qty	Loc Code
GA	99	
m133860	99	
ST310	882	
m134654	882	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____																						
Misidentified ☐	☐	Past Due ☐																							

DART AEROSPACE LTD		Work Order: 153975
Description: Bracket Assembly		Part Number: D3294-1
Inspection Dwg: D3294	Rev: D	Page 1 of 1

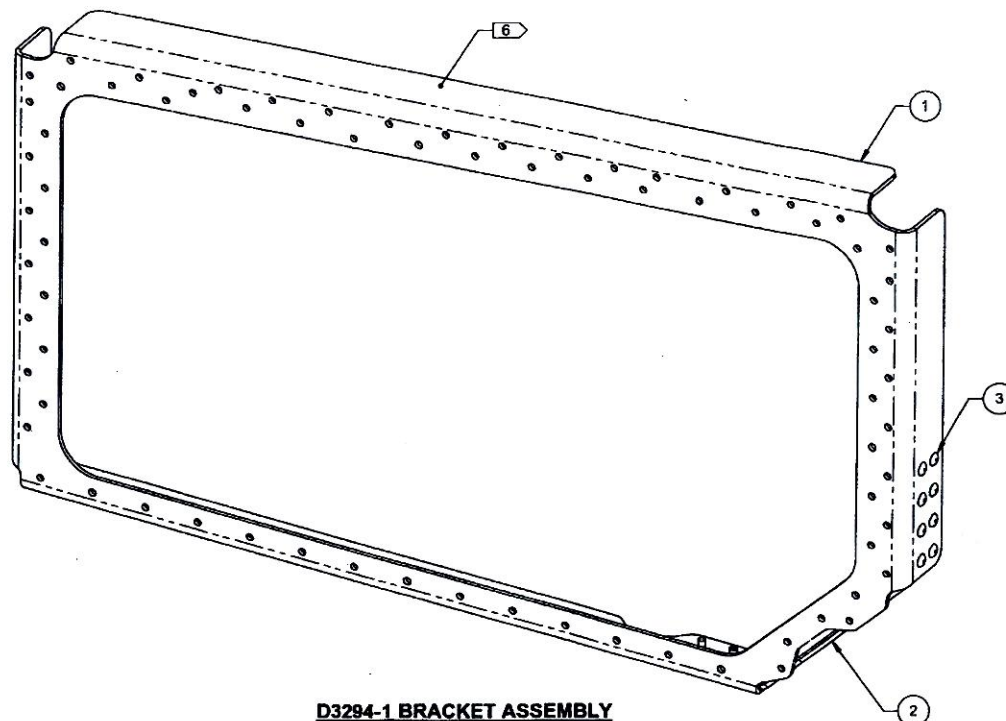
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130	✓		0c-01	
Ø0.141	+0.005/-0.001	0.142	✓		Tape	
6.708	+/-0.010	6.711	✓			
1.118	+/-0.010	1.119	✓			
5.590	+/-0.010	5.590	✓			
1.118	+/-0.010	1.118	✓			
13.563	+/-0.010	13.503	✓			
1.043	+/-0.010	1.045	✓			
0.625	+/-0.010	0.626	✓			
0.325	+/-0.010	0.328	✓			
0.300	+/-0.010	0.305	✓			
0.400	+/-0.010	0.402	✓			
6.000	+/-0.010	6.001	✓			
1.000	+/-0.010	1.002	✓			
17.124	+/-0.010	17.124	✓			
16.13	+/-0.030	16.13	✓			
7.27	+/-0.030	7.278	✓			
11.97	+/-0.030	11.97	✓			
8.37	+/-0.030	8.376	✓			
20.05	+/-0.030	20.05	✓			
12.98	+/-0.030	12.98	✓			
14.59	+/-0.030	14.59	✓			
11.66	+/-0.030	11.66	✓			
0.080	+/-0.010	0.079	✓			

Measured by: DAS 46 9-89	Audited by: DAS 38 9-89	Preliminary Approval:
Date: 17/01/23	Date: JAN 24 2017	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	
F	13.05.08	Dwg Rev updated	KJ	

ITEM	QTY -1	P/N	DESCRIPTION
	X	D3294-1	BRACKET ASSEMBLY
1	1	D3294-3	BRACKET
2	1	D3294-5	DOUBLER
3	15	MS20470AD4-5	RIVET



D3294-1 BRACKET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 153475 MJS
10/1/21

RELEASED
2012-11-21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1" PER DART QSI 044 6.1
- 7) WEIGHT: 0.83 lbs

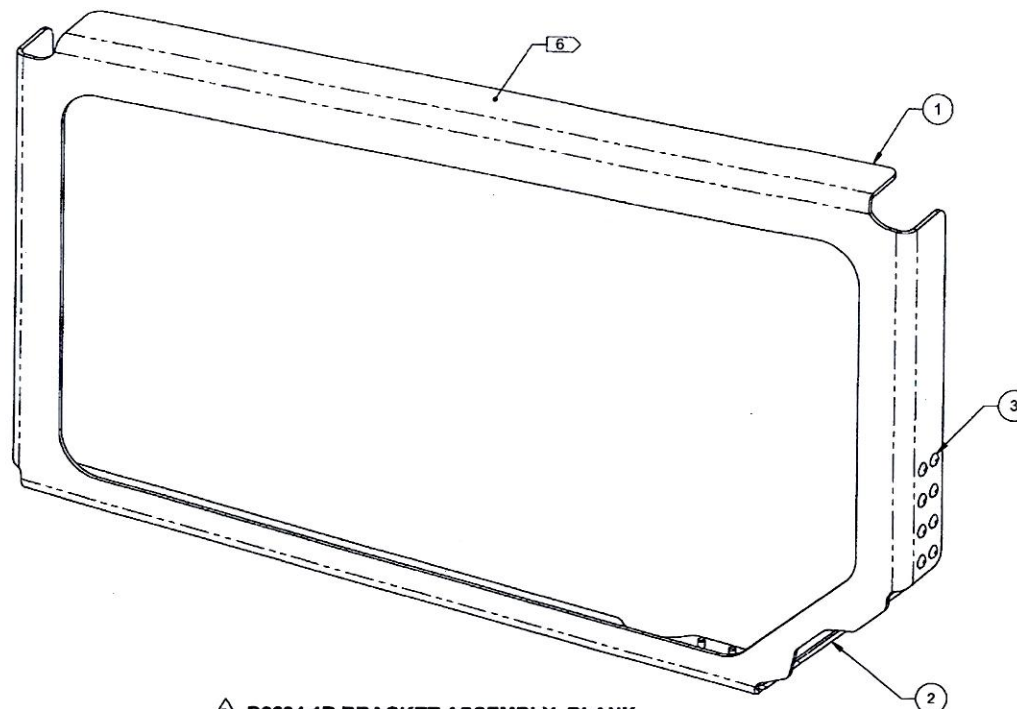
D	ADD D3294-1B/-3B/-3FB. REASON: PAR12-223.	MB	12.11.15
C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.11.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3294** REV. D
SHEET 1 OF 9
TITLE **BRACKET** SCALE NTS

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ITEM	QTY -1B	P/N	DESCRIPTION
	X	D3294-1B	BRACKET ASSEMBLY, BLANK
1	1	D3294-3B	BRACKET
2	1	D3294-5	DOUBLER
3	15	MS20470AD4-5	RIVET



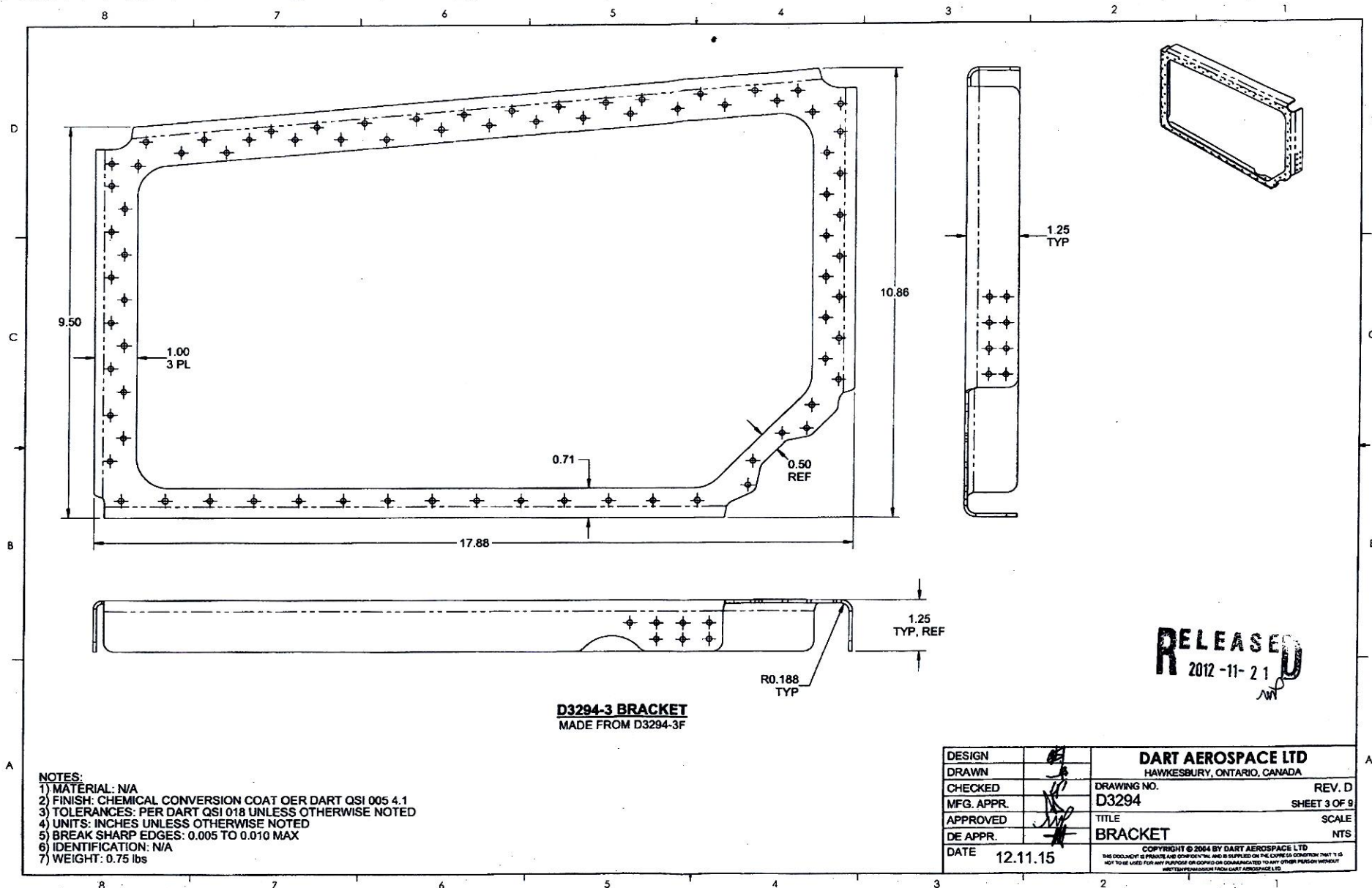
D3294-1B BRACKET ASSEMBLY, BLANK

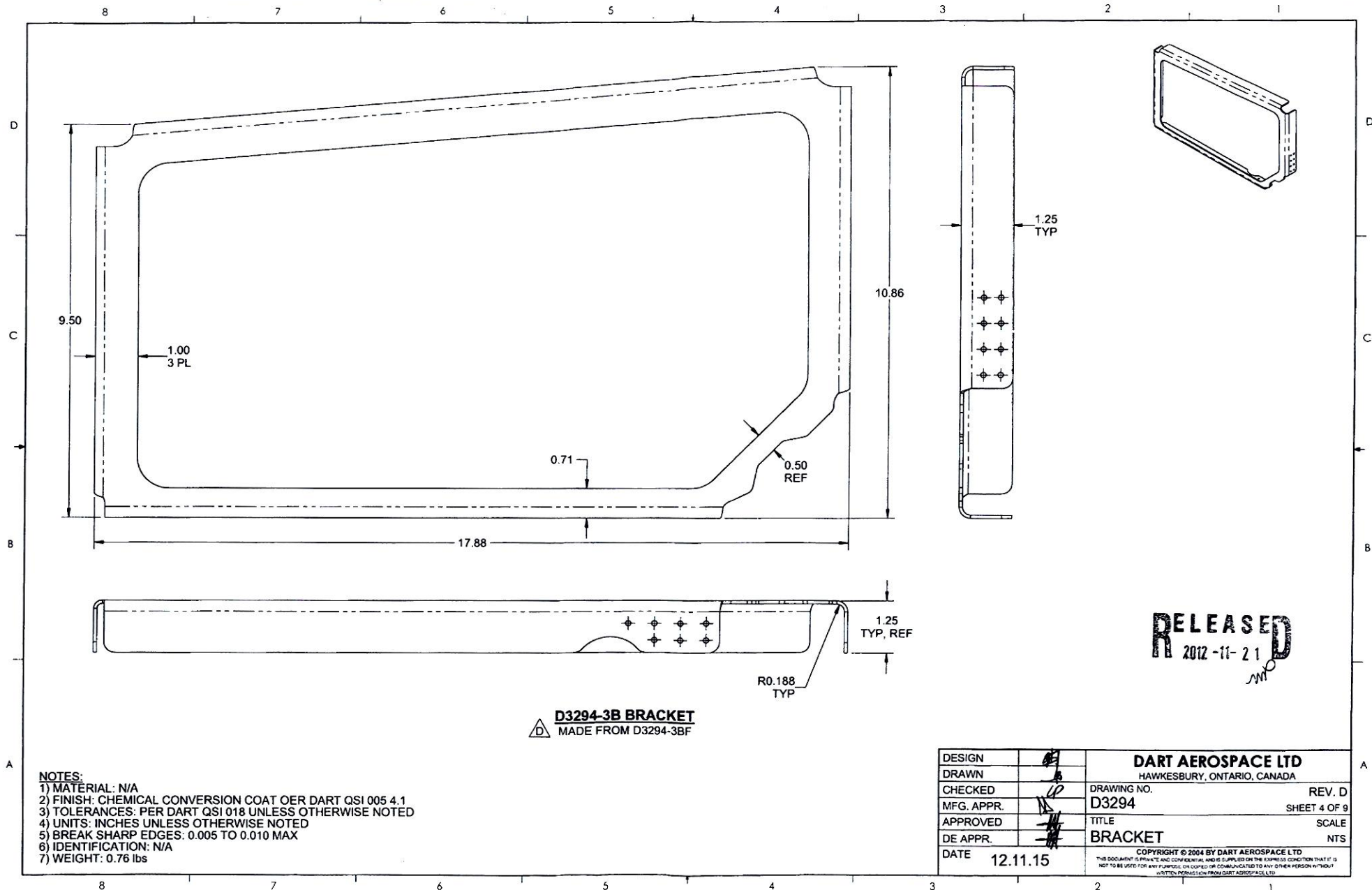
RELEASED
2012-11-21

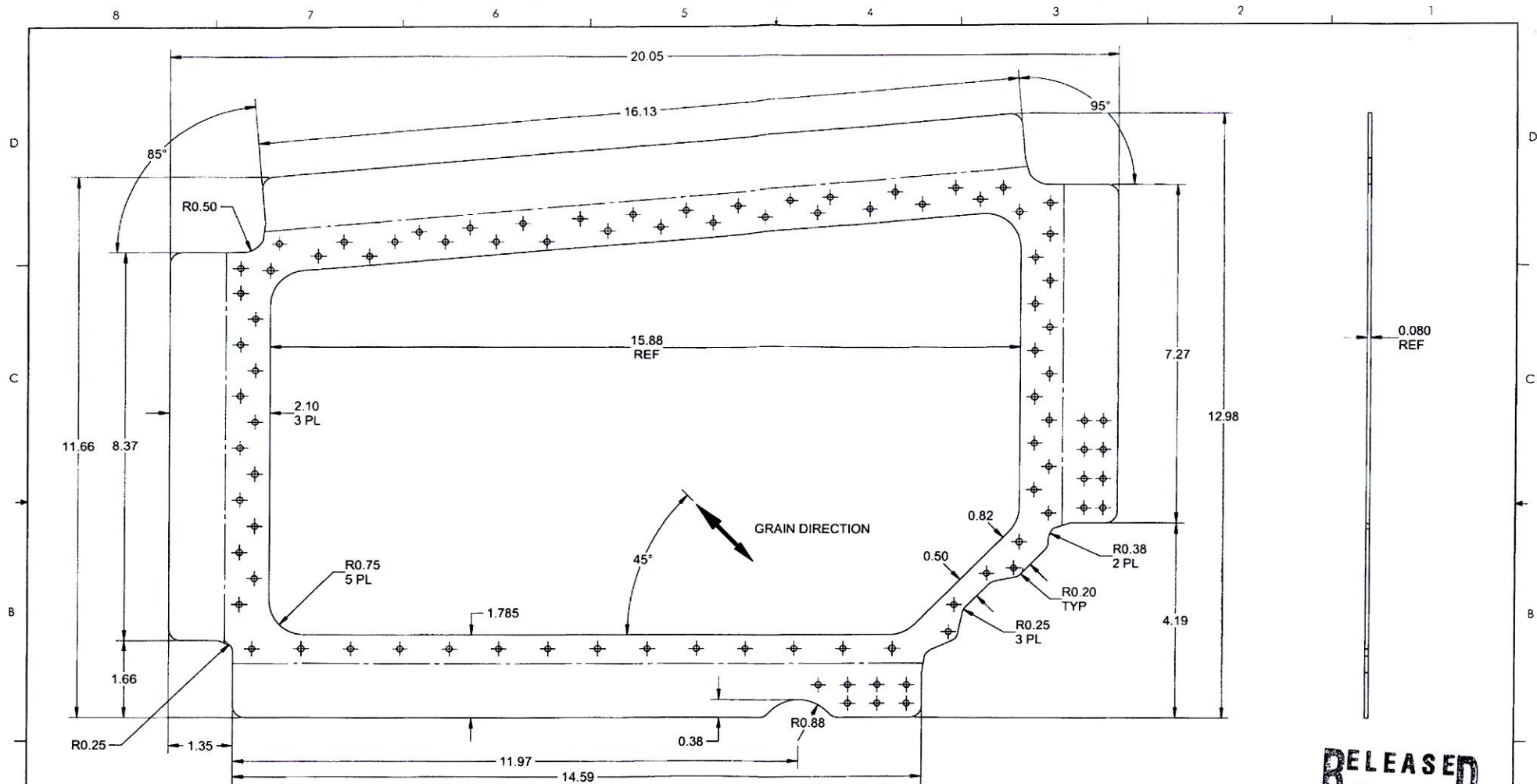
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES; 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1B" PER DART QSI 044 6.1
- 7) WEIGHT: 0.83 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3294	SHEET 2 OF 9
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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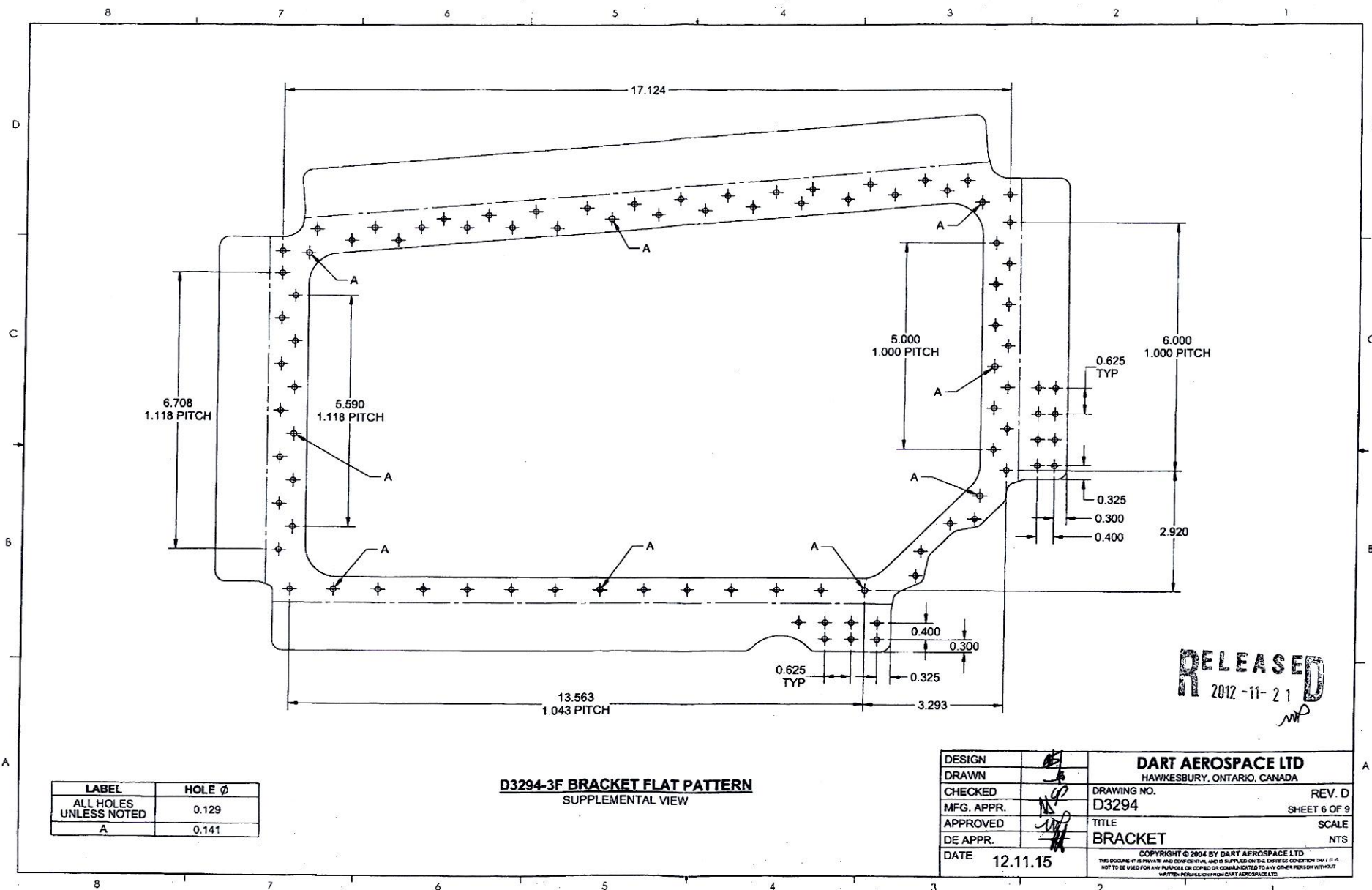
D3294-3F BRACKET FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3294	SHEET 5 OF 9
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	
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2012-11-21

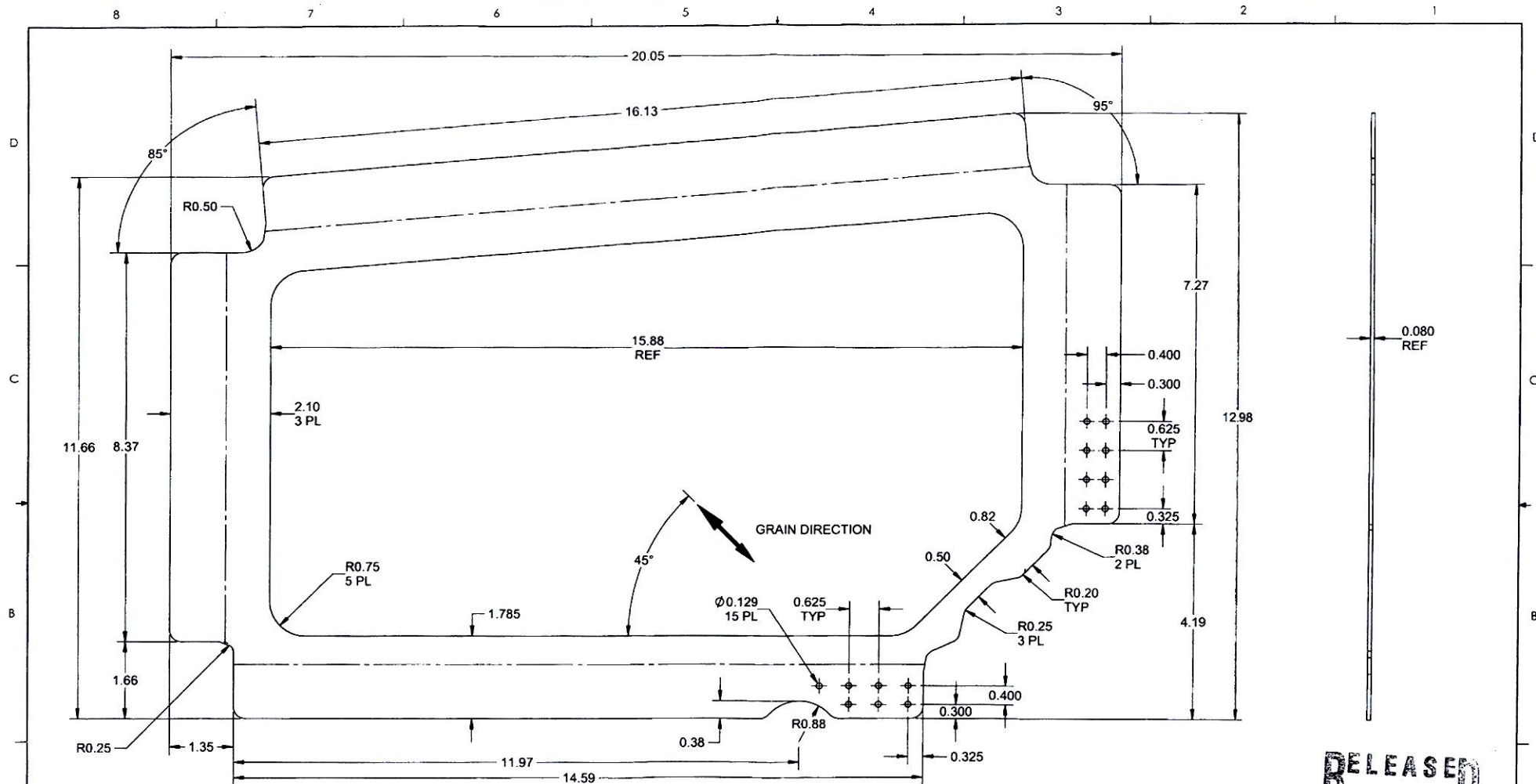


RELEASED
2012-11-21

LABEL	HOLE Ø
ALL HOLES UNLESS NOTED	0.129
A	0.141

D3294-3F BRACKET FLAT PATTERN
SUPPLEMENTAL VIEW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3294	REV. D
MFG. APPR.			SHEET 6 OF 9
APPROVED		TITLE BRACKET	SCALE
DE APPR.			NTS
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D3294-3BF BRACKET FLAT PATTERN, BLANK

RELEASED
2012-11-21

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.080)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3294	SHEET 7 OF 9
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	12.11.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	